

Work Order ID 56490

February 25, 2010 7:31:50 AM



Page 1

Item ID: D3391-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Mid Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



Skidtubes

Skidtubes

0.00

Skidtubes

Memo

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

M10/2/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56490

February 25, 2010 7:31:51 AM

Page 2

Item ID: D3391-023

Accept

Revision ID:

Item Name: Mid Tube Assembly

Setup Start

Stop

Start Date: 2/25/10 Start Qty: 1.00

Required Date: 3/05/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Open .375" holes to .438" ***do not open fwd saddle holes***

H10/2/25

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

H10/3/11

15- Locating from two fwd wearplate holes drilol remaining 6 wearplte holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D3391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56490

February 25, 2010 7:31:52 AM

Page 3

Item ID: D3391-023

Accept

Revision ID:

Item Name: Mid Tube Assembly

Setup Start

Stop

Start Date: 2/25/10 Start Qty: 1.00

Required Date: 3/05/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00

S 02/03/10

(X)

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

BE 12/03/02

(X)

HandFinish

Memo

0.00

Hand Finishing

130

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

12/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56490

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Page 4

Item ID: D3391-023

Accept

Setup Start

Revision ID:

Stop

Item Name: Mid Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00

Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open float bag holes as per dwg
2-C'sink float bag holes as per dwg
3- Prepare tube for welding
4-Bond web in place as per Dwg D3391 & QSI 015.
Adhere for 12 hours)
A/R Sikaflex exp: 01/12/29 08/2010
batch#: 01/12/29

BE 10/03/02

150

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

DP 10-3-3

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Weld crossbolt spacer as per dwg D3391 & QSI 004
2-grind weld flush

BE 10/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56490

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Page 5

Item ID: D3391-023

Revision ID:

Item Name: Mid Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00

Required Date: 3/05/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

170



QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Memo

Set Up/
Run Hours

0.00

0.00

8/10/03/03

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

40

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/03/03

20 f

190



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

0.00

0.00

11114207

START TIME: 7:00 AM
OVEN TEMPERATURE: 320° F
FINISH TIME: 7:30 AM

= 7 Jul 10/04/28

1 y

PTO = 7

W/O: 56490

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-04-22	180.1	Pressure WASH + Recalibrate ASPEN PAR 09013	gll	10/04/22	11		S 10/04/22

Part No: D3391-023 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56490

February 25, 2010 7:32:11 AM

Page 6

Item ID: D3391-023

Accept

Revision ID:

Item Name: Mid Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00

Required Date: 3/05/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

①

BR 10-4-28.

210

Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1- insert D3391-021 into D3391-23

2- insert T-pins into first and third fwd saddle holes

3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364

4- remove T-pins and locate DT9415 from first and third crossbolt hole using T-pins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

① BR

10-4-28.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56490

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Page 7

Item ID: D3391-023

Accept

Revision ID:

Item Name: Mid Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00

Required Date: 3/05/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/10/09/09

230



HandFinish

Hand Finishing

HandFinishing

Memo

Install Inserts as per Dwg

0.00

0.00

DL 10-24-28.

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/10/09/09

DL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56490

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Page 8

Item ID: D3391-023

Accept

Revision ID:

Item Name: Mid Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00

Required Date: 3/05/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Identify as per dwg & Stock Location: 58198 0.00



Packaging

Memo

D412-742-043 0.00

Packaging

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

1 BR 10-4-28

10/04/30

MF
10-4-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 25, 2010 7:31:48 AM

Page 1

Work Order ID: 56490

Parent Item: D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 2/25/10

Required Date: 3/05/10

Comments: IPP A: 05.10.20 New Issue KJ/EC
IPP B: 06.02.10 :ECN773 dwg rev.D EC: I
IPP C: 07.03.20 rev F dwg EC
IPP D: 07.03.28 re-format EC

Start Qty: 1.00

Required Qty: 1.00

D2500-1-100



Skidtube Extrusion

Manufactured No 100 Each 137.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

If 87

50251 87

Main Warehouse

ST 50

37065 50

D3391-021



Fwd Tube Assembly

Manufactured No 100 Each 0.0000 1.0000



D3389-1



Web

Manufactured No 140 Each 1.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1

48244 1

Q56510

①

BE 10/63/02

1 M10/13/1

56215 BR 10-429

1 M10/2/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 25, 2010 7:31:49 AM

Page 2

Work Order ID: 56490

Parent Item: D3391-023

Parent Item Name: Mid Tube Assembly

Comments: IPP A: 05.10.20: New Issue!
IPP B: 06.02.10: ECN773 dwg rev.D
IPP C: 07.03.20: rev F dwg
IPP D: 07.03.28: re-format

KJ/EC
EC
EC
EC

Start Date: 2/25/10

Start Qty: 1.00

Required Date: 3/05/10

Required Qty: 1.00

D3681-1



Spacer

Manufactured No 160 Each 39.0000 5.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 37

51920 20

52898 17

Main Warehouse

ST 2

47123 2

5 EC 4/23/03

D3591-1



Bushing

Manufactured No 210 Each 37.0000 2.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 57350 37

46105 29

47121 8

1 10-4-28

February 25, 2010 7:31:49 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 3

Februdry 25, 2010 7:31:49 AM

Work Order ID: 56490



Parent Item: D3391-023



Parent Item Name: Mid Tube Assembly

Start Date: 2/25/10

Required Date: 3/05/10

Comments: IPP A 05.10.20 New Issue KJ/EC:
 IPP B 06.02.10 ECN773 dwg rev.D EC
 IPP C 07.03.20 rev F dwg EC
 IPP D 07.03.28 re-format EC

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

230

Each

1,678.000 22.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

110511

1678

1678

20, BR 10-4-08

February 25, 2010 7:31:49 AM

Shop Packet Print

Page 3

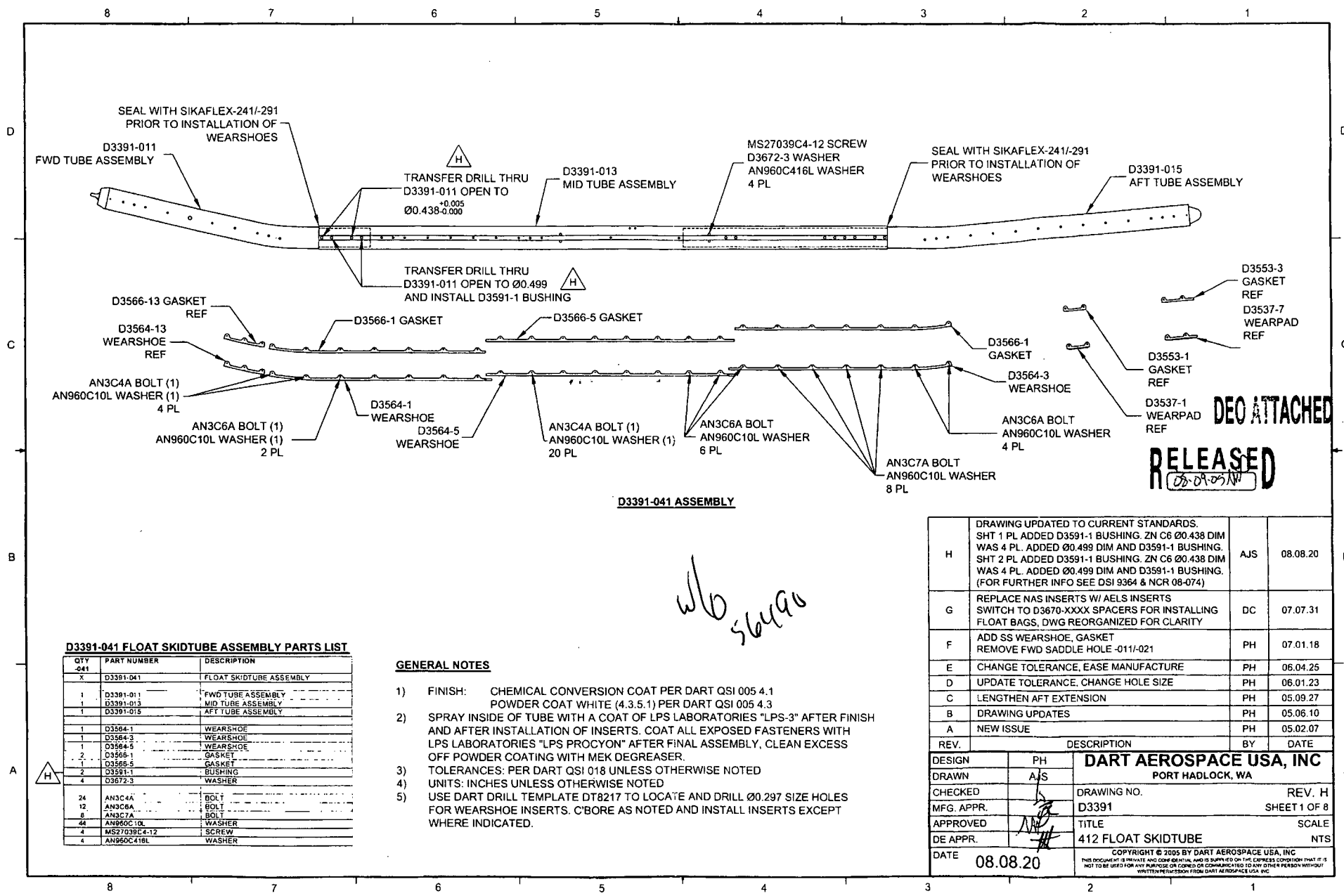
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DEO ATTACHED
RELEASED
08-09-05 NW

D3391-041 ASSEMBLY

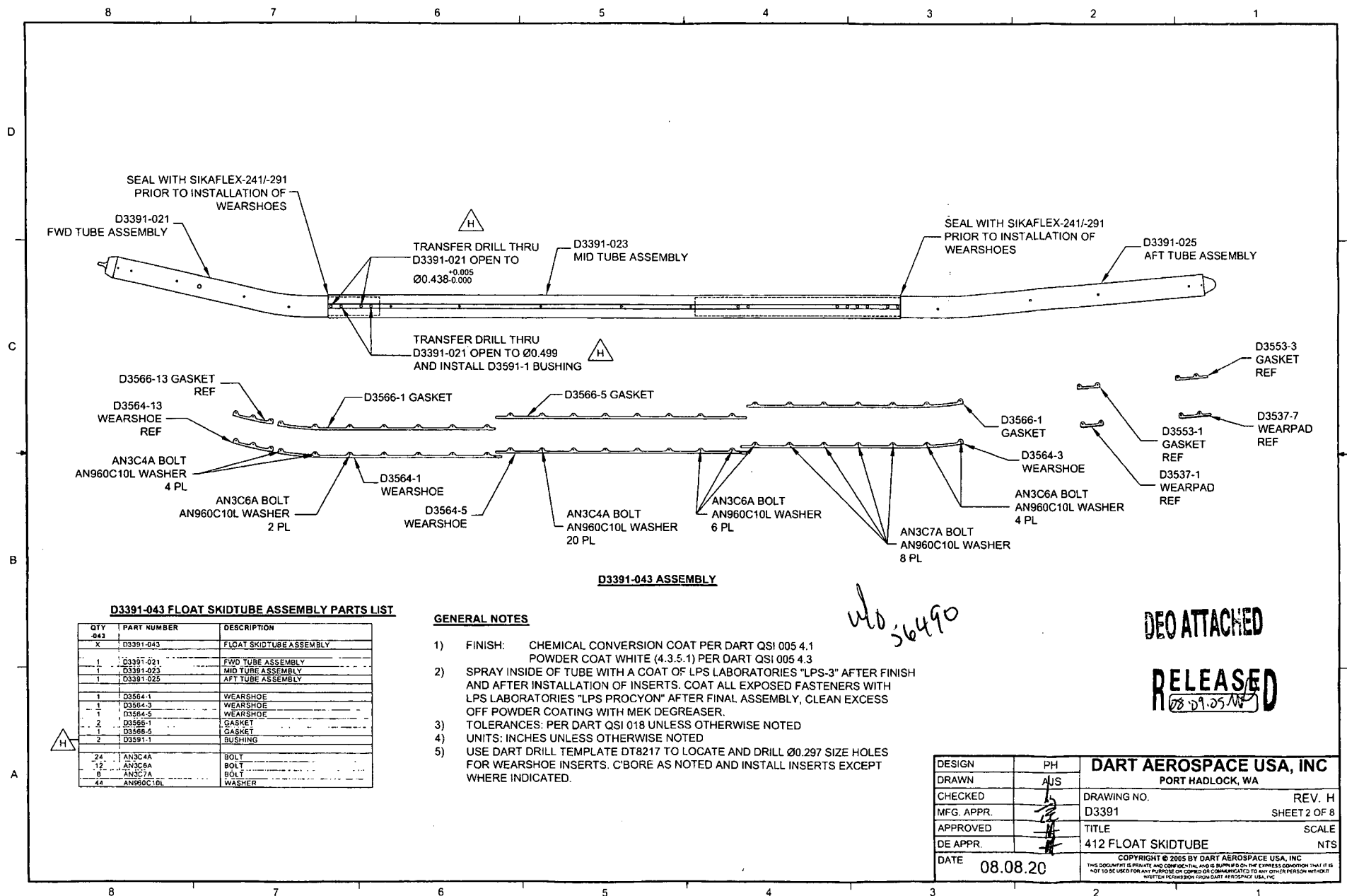
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	Float Skidtube Assembly
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-2	WEARSHOE
1	D3564-3	WEARSHOE
2	D3566-1	GASKET
2	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

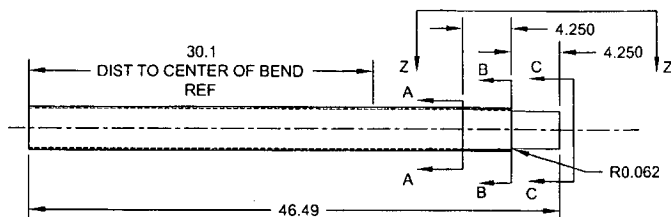
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS. DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

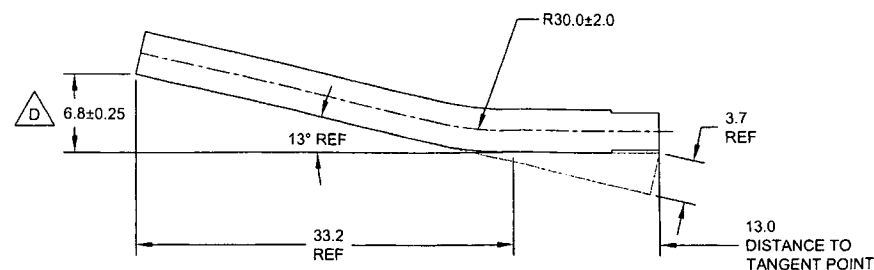


DEO ATTACHED

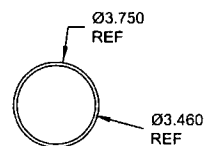
RELEASED
08-09-25



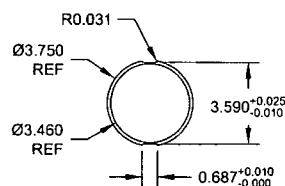
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



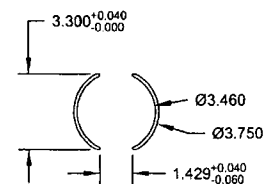
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



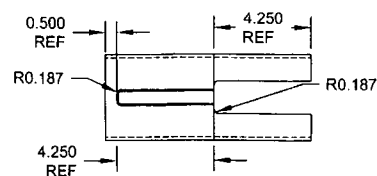
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

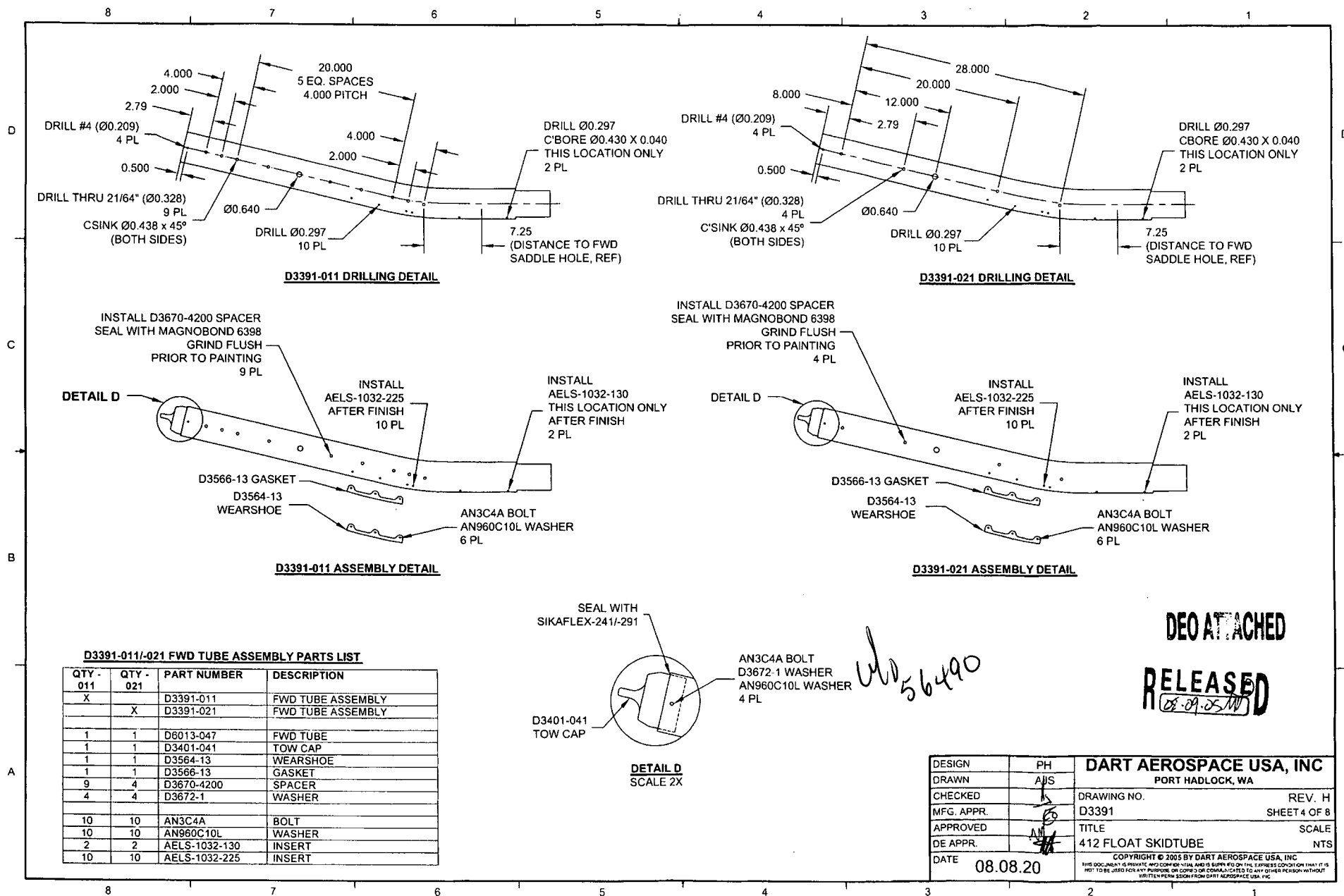


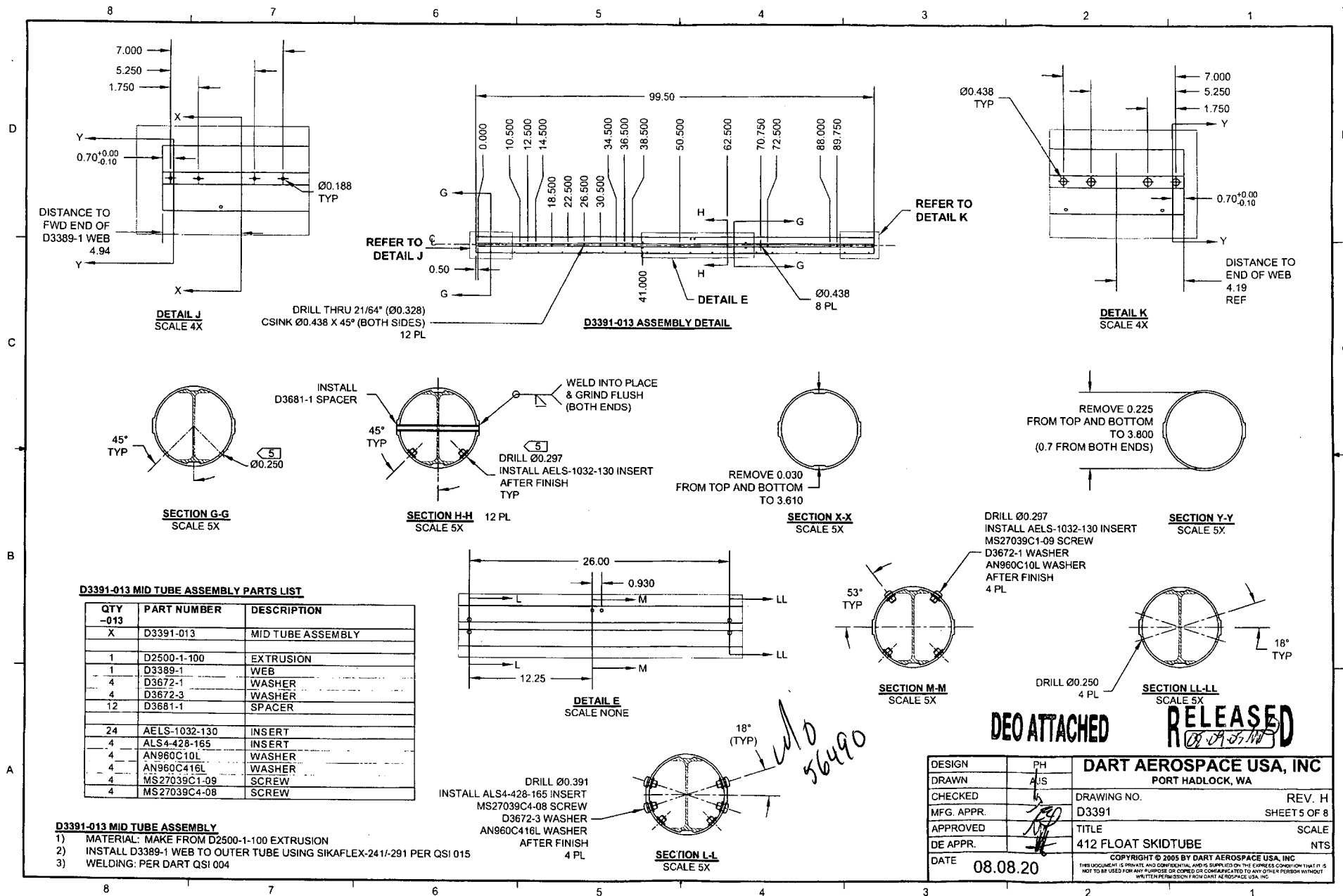
VIEW Z-Z
SCALE 2X

Wb 50490

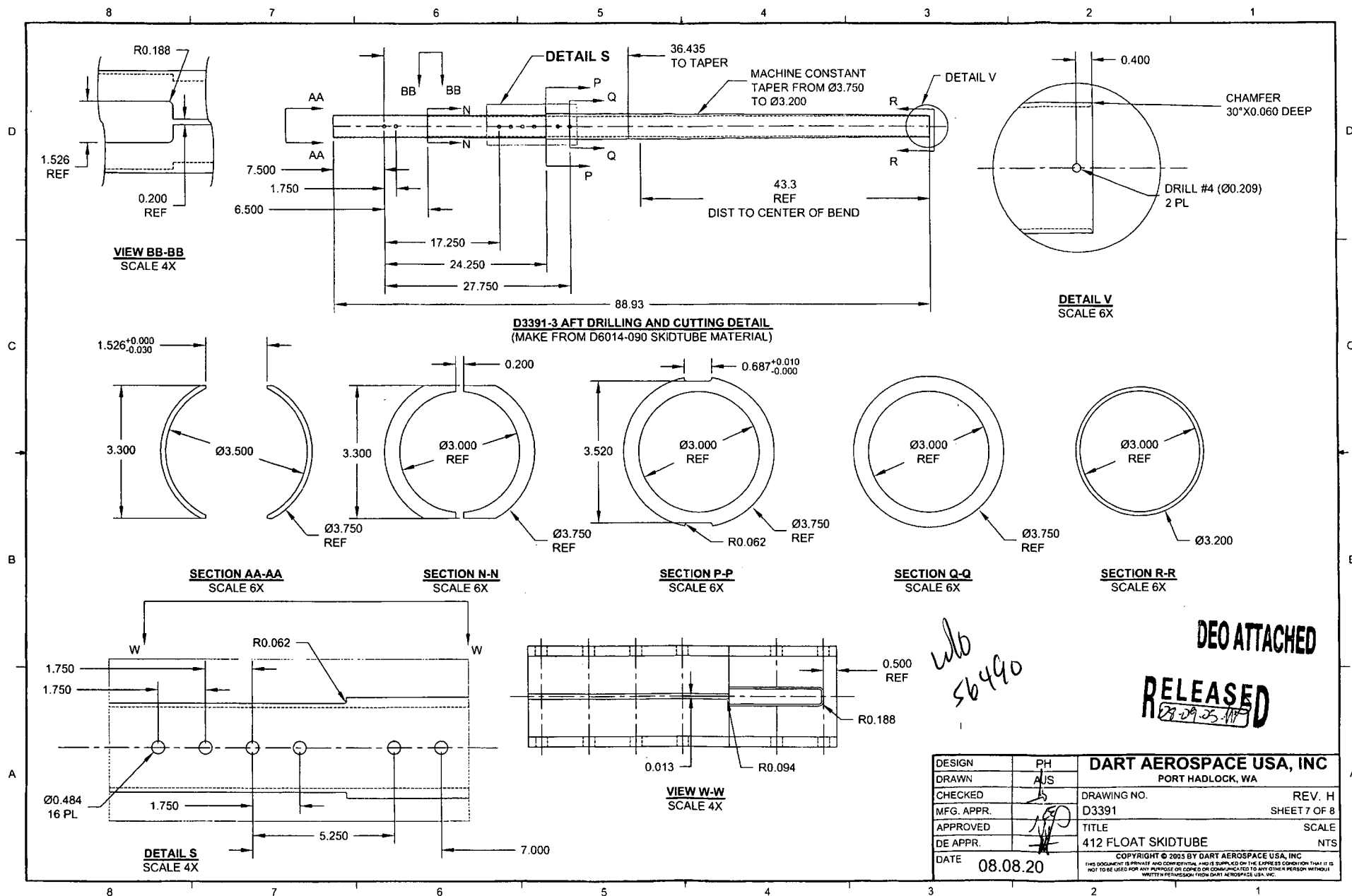
DEO ATTACHED
RELEASED
21-0511

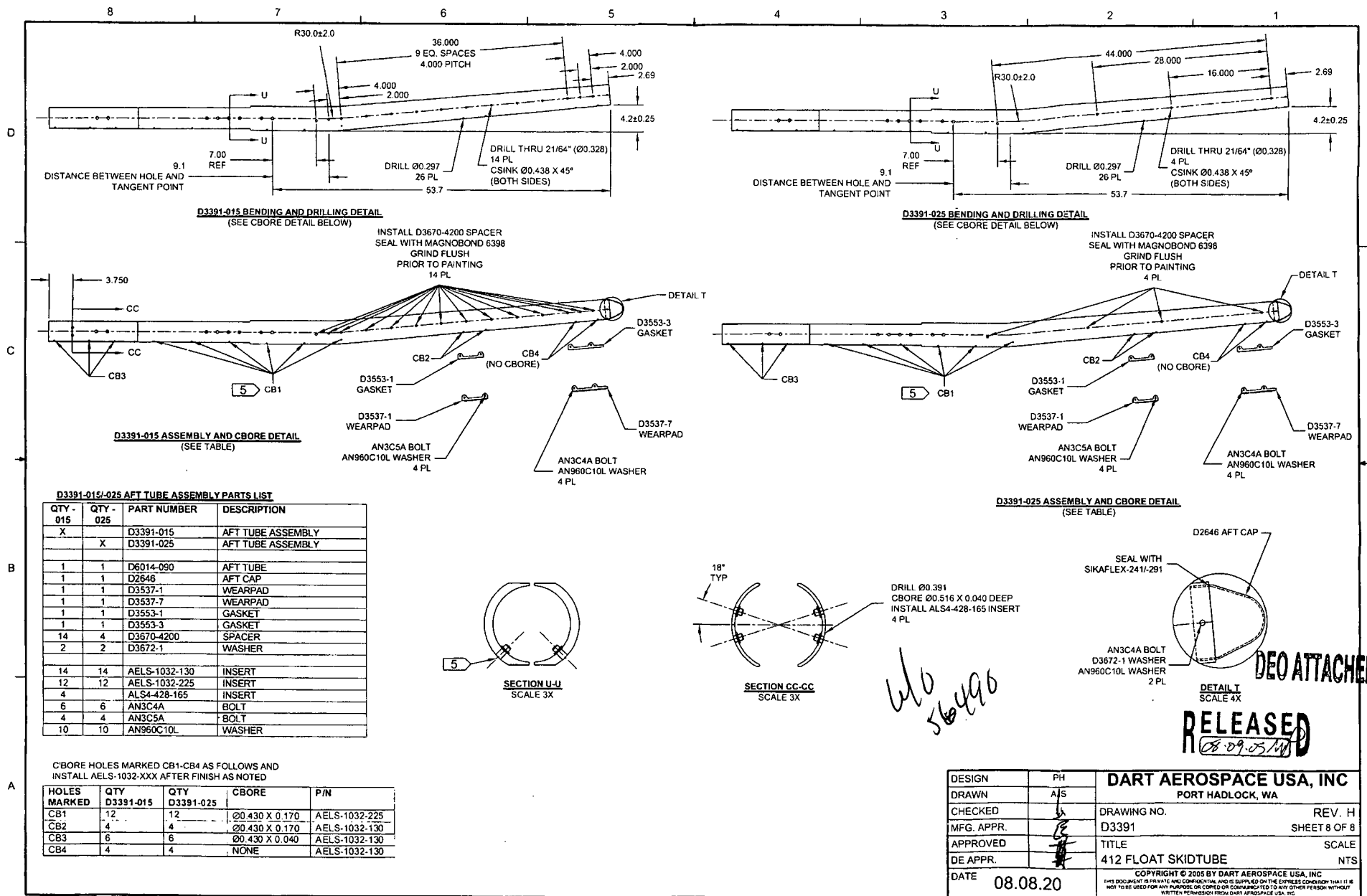
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG. APPR.		TITLE	SHEET 3 OF 8
APPROVED		412 FLOAT SKIDTUBE	SCALE
DE APPR.			NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS HEREBY MADE CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	











DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

WLB
56490

NO. 224

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Burclay Elliott
Job number: 53938
Part number: D3391-023
Description: Hot Mid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 10-02-18

Welder [Signature] Date of Test Coupon 10-02-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld